

Work Order ID 85359

85359

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Item ID: D412-698-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cabin Door Roller, LH

Stop

NS2

Start Date: 06/06/2012 Start Qty: 200

2

Required Date: 20/06/2012 Req'd Qty: 200

2

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/07 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D412-698-011 CHG003								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DA-16 12/05/10
2-89
JB

1 12/08/10 JB

DA-16 12/05/10
2-89

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Item ID: D412-698-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Cabin Door Roller, LH

Stop *NS2*

Start Date: 06/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-011
Location: _____

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 12/08/10

MF
12-08-10

Picklist Print

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Work Order ID: 85359

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Parent Item: D412-698-011

D412-698-011

Parent Item Name: Cabin Door Roller, LH

Start Date: 06/06/2012

Required Date: 20/06/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.26Change Qty of D3121-141 & remove D3121-145 from
Step 1,3KJ/DS
IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-141		Manufactured	No			100	Each	18.0000	3	84714			
D3121-141									**				
Bracket Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235		18							
				83457		18							
D3121-143		Manufactured	No			110	Each	4.0000	0	2			
D3121-143									**				
Bracket Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235A		4							
				80098		4				80098			
D3183-043		Manufactured	No			110	Each	5.0000	0	2			
D3183-043									**				
Bracket Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235B		5				82688			
				82688		5				82688			
D3137-043		Manufactured	No			110	Each	2.0000	0	2			
D3137-043									**				
Bracket Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235B		2				83467			
				79734		2				83467			

Picklist Print

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Work Order ID: 85359

Parent Item: D412-698-011

Parent Item Name: Cabin Door Roller, LH

85359

D412-698-011

Start Date: 06/06/2012

Required Date: 20/06/2012

Start Qty: 2.00

Required Qty: 2.00

D3199-1

Manufactured No

110

Each

109.0000

S *D3199-1*
Bracket

**

6x85467 JB 8P

Location

Loc Qty

Loc Code

ST236

114

78618

2

83267

63

83860

44

ST236A

-5

D3202-1

Manufactured No

110

Each

25.0000

S *D3202-1*
Cover

**

JB 12/08/10

Location

Loc Qty

Loc Code

ST241A

25

70294

2

82663

9

83506

14

82663

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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